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D4672-1

Job Sheet 197693

DAS
21
9-59

Part No: D4672-1

Job Qty: 38 pcs

Part Name: Blanking Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/12/19

Job Tracking No:

Due Date: 7/30/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 12-07-10 JLM VERIFIED BY:EC IPP REV:B 12.07.24 AS PER DWG
REV:A DD VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	33 pcs	7/30/19	7/30/19	0.03	3.03	Waterjet - Flow	9/11/19	JRB
120	QC 8	33 pcs	7/30/19	7/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
180	Packaging 3-1 - Stock - B4B	33 pcs	7/30/19	7/30/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		
							Packaging 3 - 13 - B4B		
							Packaging 3 - 14 - B4B		
							Packaging 3 - 15 - B4B		

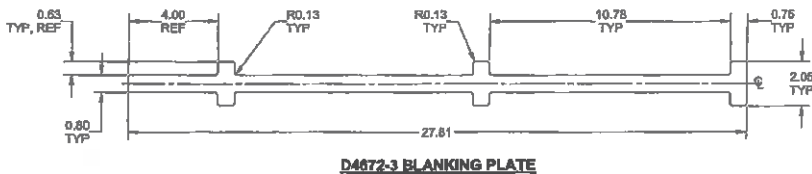
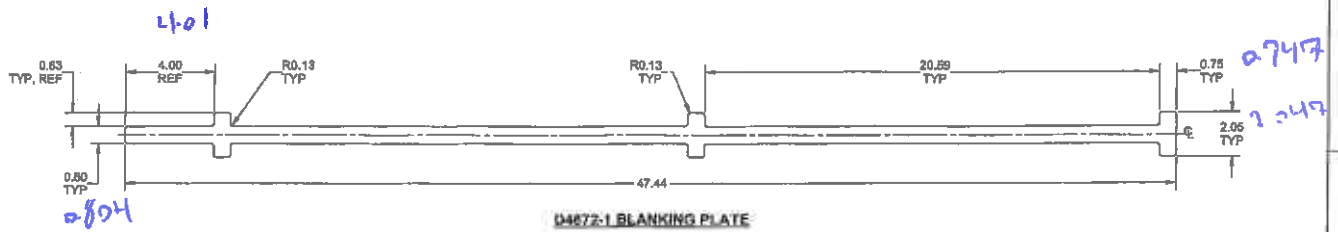
Plex 7/12/19 3:10 PM Dart.Renwick.Jennife

				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
190 QC 21 - SA	33 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 180 - (Identify as per dwg & Stock Location: _____) 190 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S20GA	304/316 .040 Sheet	22.4400 sf (.68 ea)	100-Waterjet - Flow - 1	3175151	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S20GA	22	196	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Blanking Plate	0.800Inches ± 0.030	0.830 0.770		
2	Blanking Plate	0.750Inches ± 0.030	0.780 0.720		
3	Blanking Plate	2.050Inches ± 0.030	2.080 2.020		
4	Blanking Plate	20.590Inches ± 0.030	20.620 20.560		
5	Blanking Plate	4.000Inches ± 0.030	4.030 3.970		
6	Blanking Plate	0.630Inches ± 0.030	0.660 0.600		
7	Blanking Plate	47.440Inches ± 0.030	47.470 47.410		
8	Blanking Plate	0.040Inches ± 0.010	0.050 0.030		

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 197693



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED 2B FINISH PER MIL-S-5069 OR AMS 6513 (304) OR AMS 6624 (316) OR ASTM A240 OR ASME SA240 REF DART SPEC M004S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART Q91 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4672-X" PER DART Q91 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: D4672-1 = 0.47 lbs; D4672-3 = 0.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE OF PART

RELEASED
2012-07-10
P. 2012-07-10

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4672	REV. A
MFG. APPR.			SHEET 2 OF 2
APPROVED		TITLE BLANKING PLATE	SCALE
DE APPR.			NTS
DATE	12.06.13		